

# Work Order ID 60075

June 24, 2010 9:04:51 AM



Page 1

Item ID: D3245-042

Accept



Setup Start

Revision ID:



Item Name: Access Panel Assembly

Stop



Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3245

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245 be careful when countersinking...mat'l very thin

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8/10/08/03*

*8/10/08/03 (4)*

*8/10/08/03 (4)*

*(4)*

*042*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60075

June 24, 2010 9:04:52 AM



Page 2

Item ID: D3245-042

Accept

Revision ID:

Item Name: Access Panel Assembly

Start Date: 6/24/10 Start Qty: 4.00

Required Date: 7/02/10 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: *231*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start

Stop

Cust Item ID:

Customer:



*10/8/4*

*SP (4)*

*10/8/04*

*10-8-04*  
*(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:04:50 AM

Page 1

Work Order ID: 60075

Parent Item: D3245-042

Parent Item Name: Access Panel Assembly



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2350-18-C3Y  RIGID RECEPTACLE		Purchased	No			110	Each	196.0000	8	32			
				<u>Location</u>									
				ST399				196					
				111129				26					
				111581				75					
				19688				95					
D3245-2  Panel		Manufactured	No			110	Each	2.0000	1	4			
				<u>Location</u>									
				ST233A				2					
				43902				2					
D3245-5  Door		Manufactured	No			110	Each	27.0000	1	4			
				<u>Location</u>									
				ST233B				27					
				47591				15					
				47610				12					

32  
E/S 10/08/03

32  
4  
E/S 10/08/03  
B60078 (2x)

2  
4  
E/S 10/08/03  
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:04:51 AM

Page 2

Work Order ID: 60075

Parent Item: D3245-042

Parent Item Name: Access Panel Assembly



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

MS20427M3-3

Purchased

No

110

Each

532.0000

16

64



Rivet

## Location

## Loc Qty

ST318

532

112933

8

113064

524

MS20615M3-3

Purchased

No

110

Each

123.0000

9

36



Rivet

## Location

## Loc Qty

ST323

123

108558

23

111650

100

## Loc Code

## Loc Code



6/24/08/03

64  
36  
6/24/08/03

36

June 24, 2010 9:04:51 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

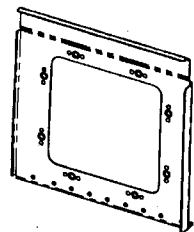
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

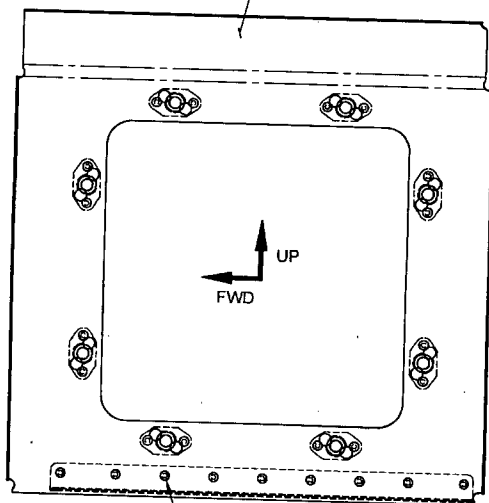
**NOTE:** Date & initial all entries





D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-041 ACCESS PANEL ASSEMBLY**

**RELEASED**  
07-10-23

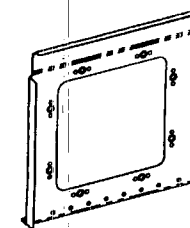
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

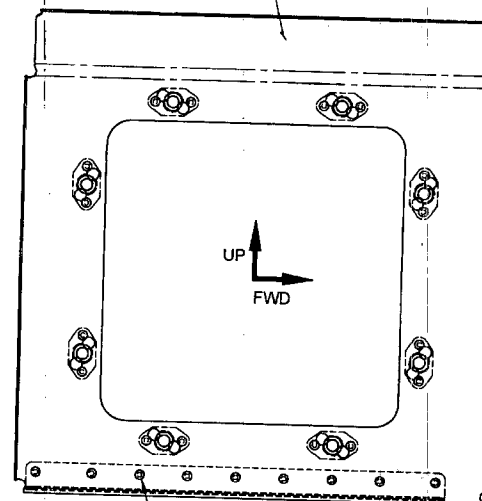
2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



D3245-5  
ANGLE PLATE

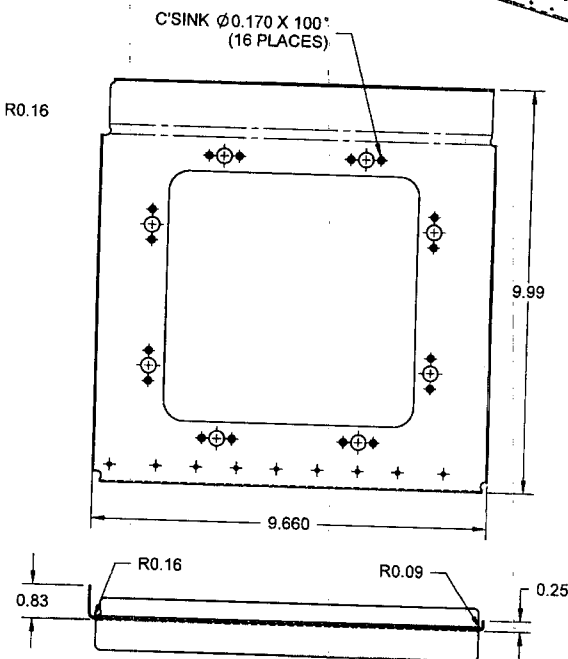
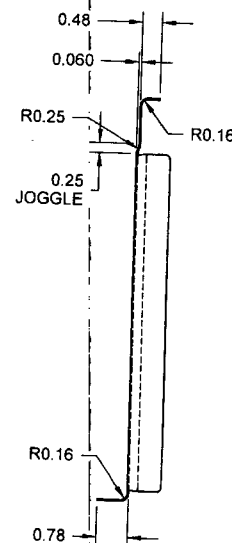
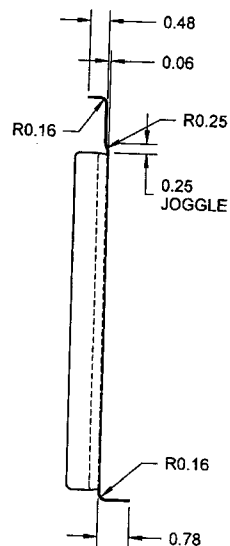
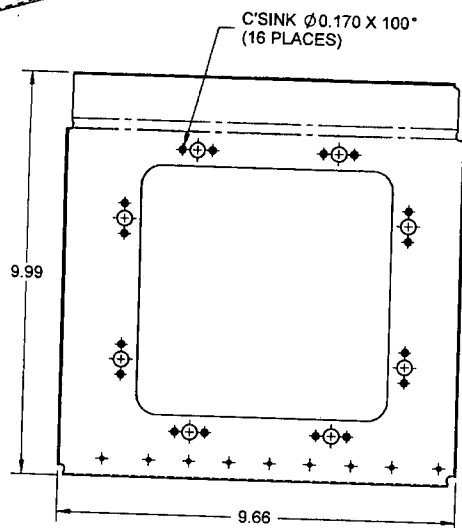
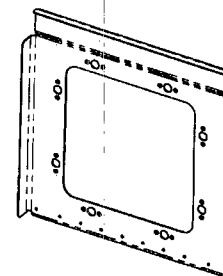
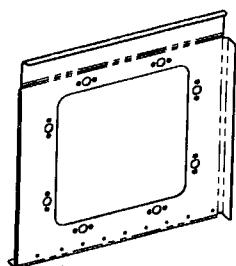
0.032  
GAP



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

B		REMOVE Ø0.204 HOLES FROM D3245-1-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN PINS TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	DART AEROSPACE LTD			REV. B	
DRAWN	HAWKESBURY, ONTARIO, CANADA			SHEET 1 OF 7	
CHECKED	DRAWING NO.			SCALE	
MFG. APPR.	D3245			1:2.5	
APPROVED	TITLE			ACCESS PANEL ASSEMBLY	
DE APPR.	DATE			07.10.02	
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D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED  
07-10-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

DESIGN	<i>TH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>B</i>		
CHECKED	<i>TH</i>	DRAWING NO. D3245	REV. B
MFG. APPR.	<i>TH</i>		SHEET 2 OF 7
APPROVED	<i>TH</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	ACCESS PANEL ASSEMBLY	1:3
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8 7 6 5 4 3 2 1

D3245-5 DOOR

2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)

D3245-7 GASKET  
(REF)

8.00  
(TYP, REF)

**D3245-043 DOOR ASSEMBLY**

INSTALL D3245-7  
GASKET ON THIS SIDE

*60075*

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

**NOTES:**

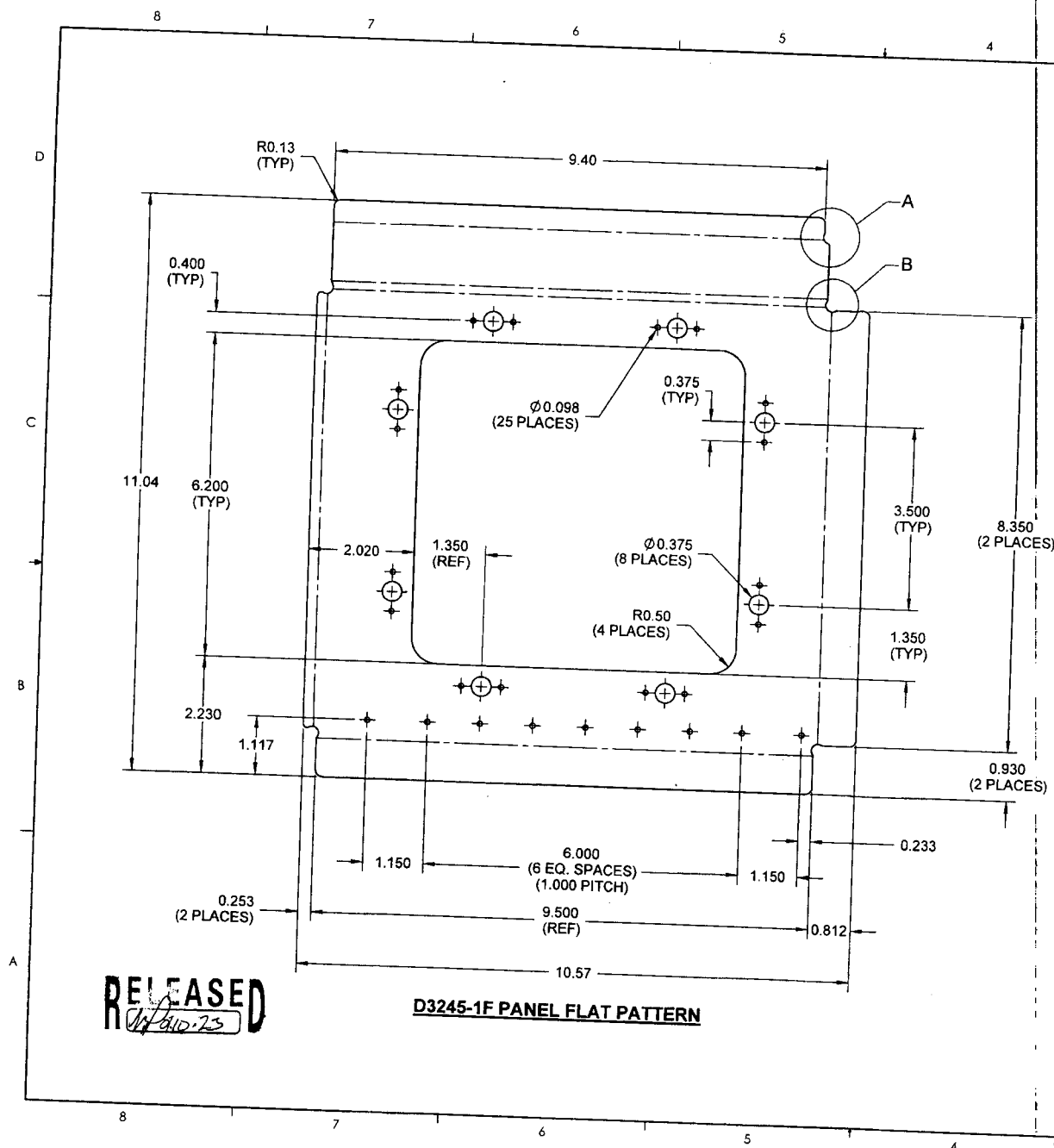
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

**RELEASED**  
*WP 27-D-33*

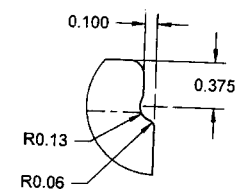
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DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. <b>D3245</b>
MFG. APPR.	<i>SS</i>	REV. B
APPROVED	<i>SS</i>	SHEET 3 OF 7
DE APPR.	<i>SS</i>	TITLE <b>ACCESS PANEL ASSEMBLY</b>
DATE	07.10.02	SCALE 1:2

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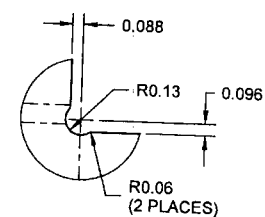
8 7 6 5 4 3 2 1



**D3245-1F PANEL FLAT PATTERN**



**DETAIL A: RELIEF**  
SCALE 1:1

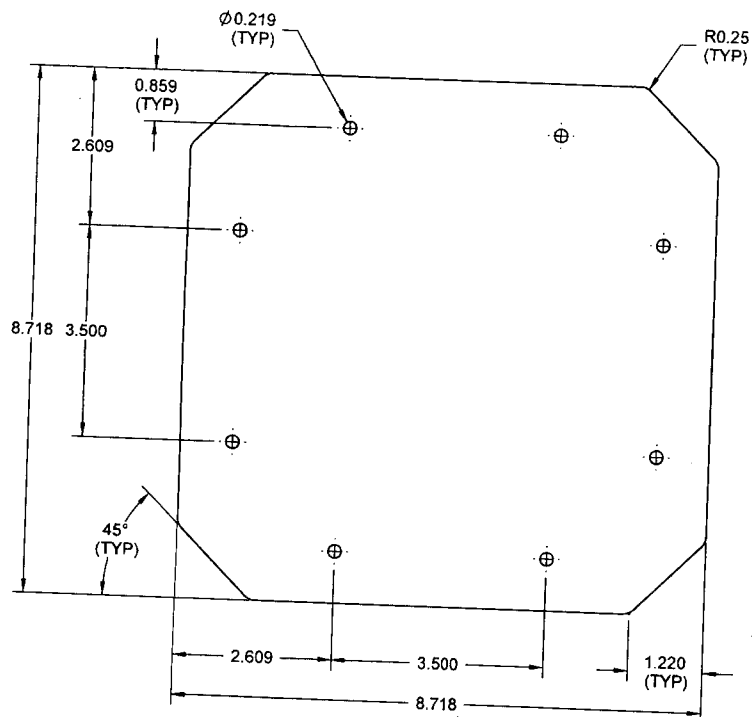


**DETAIL B: RELIEF**  
(TYP. 4 PLACES)  
SCALE 1:1

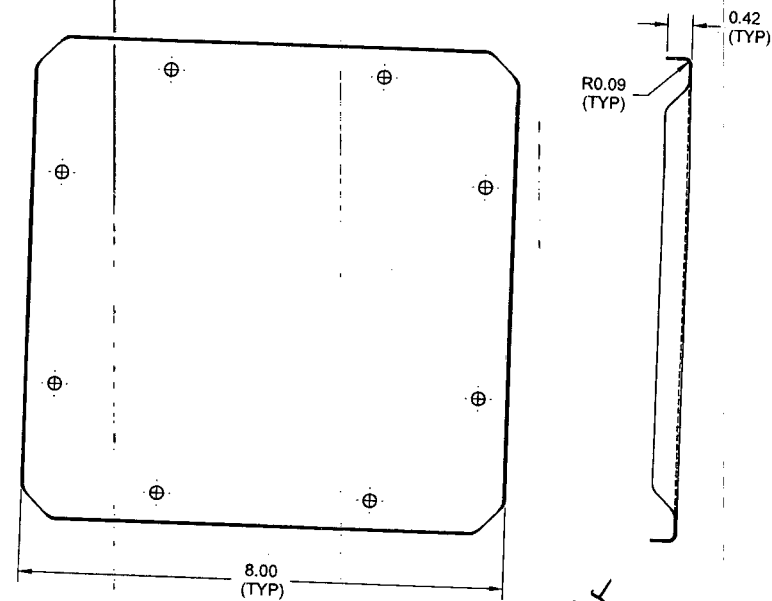
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET  
(0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	#	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	<b>D3245</b>	SHEET 4 OF 7
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	<b>ACCESS PANEL ASSEMBLY</b>	1:2
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**D3245-3F DOOR FLAT PATTERN**

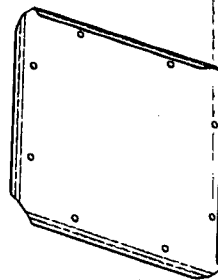


**D3245-3 DOOR BENDING DETAIL**

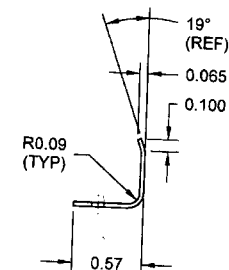
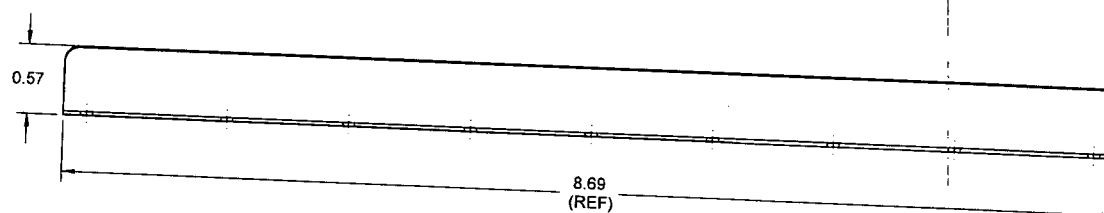
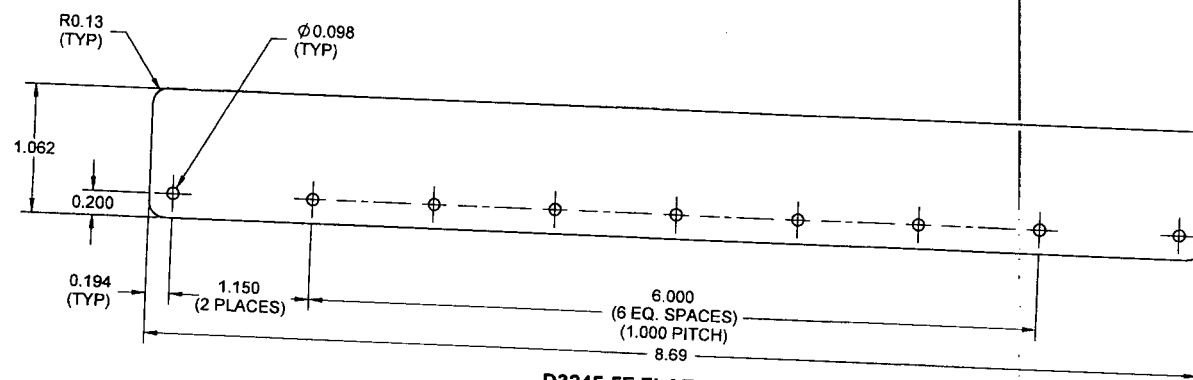
**RELEASED**  
07-10-02

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs



DESIGN	TH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	TH			
CHECKED	TH		DRAWING NO.	REV. B
MFG. APPR.	TH		D3245	SHEET 5 OF 7
APPROVED	TH		TITLE	SCALE
DE APPR.	TH		ACCESS PANEL ASSEMBLY	1:2
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD		
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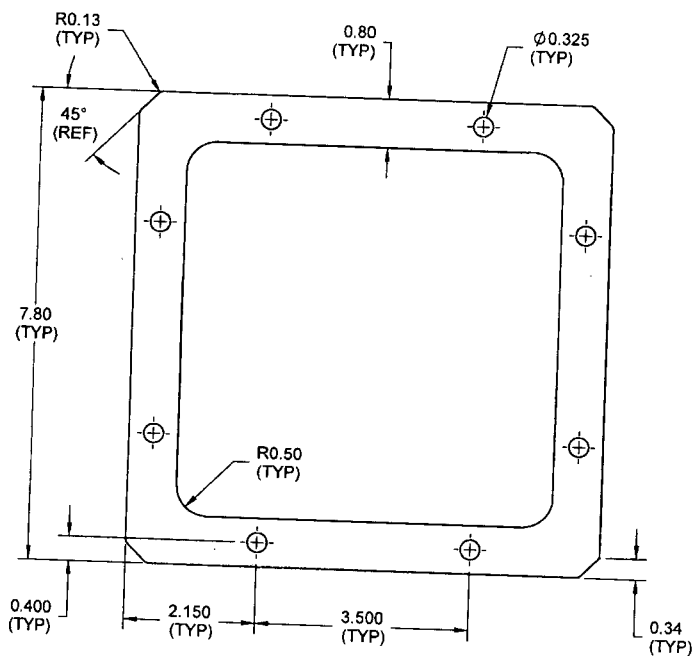
**RELEASED**  
07.10.23

60075

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	7F	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	DS	<b>D3245</b>	SHEET 6 OF 7
MFG. APPR.	MD	TITLE	SCALE
APPROVED	7F	<b>ACCESS PANEL ASSEMBLY</b>	1:1
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

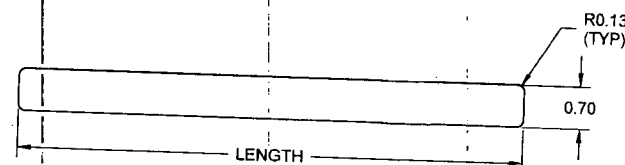


**D3245-7 GASKET**

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

00075

DESIGN	7#	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	PH	
CHECKED	DS	DRAWING NO. <b>D3245</b>
MFG. APPR.	MD	REV. B
APPROVED	MD	SHEET 7 OF 7
DE APPR.	MD	TITLE <b>ACCESS PANEL ASSEMBLY</b>
DATE	07.10.02	SCALE 1:2

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